<b>Work Ord</b> <i>uly-23-13 12:3</i>		1996		*104				Page 1			
tem ID: Revision ID:	D3916-041			Accept	*N900	040	100	)* 5	Setup Star	I VI	S1*
tem Name:	Rib Assembly		,						Sto	P *N:	S2*
tart Date: Required Date:	7/23/13 : 7/23/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* 6° *4*	K	Cust Item l Customer:	ID:					
Reference:	Process Pla	n: Mr2	Date: 13-07-15	Tooling: _ SPC (Y/N):		ate:		I	Run Star Sto	" <b>!\</b>	R1* R2*
Sequence ID/ Work Center I		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp.
Draw Nbr	Rev	ision Nbr					-				
D3916	Α										
00	<del></del>		٧.	0.00							·
*100* Large Fab		Memo	ş*	0.00				(x6)_	<del>-</del>	me	<u> 13-08</u> .
arge Fab.		*** Make 1 side of tube - 3- Trim acc	50" be with manuel pipe bender a ine at 9.00" and use jig for o when bending*** cess tube material to finish side chamfer holes as per dwg E	ther lines, and ensure se ze as per dwg D3916	eam in place on				•		
105		QC6- Inspect dimension	ns to drawing	0.00	, •		₹			•	0As
*105*					,	,			13-0	18-36	09
QC		Memo		0.00		_					

Quality Control

											DQA:	Dat	e:
NCR:	Yes	/ No				WORK ORDER NON-	COI	VFOR!	MANCE / UPDATE		QA Closed:	 Dat	01
		<del></del>						_	···		QA Closeu.	Dat	е.
Work Ord	or:					DISPOSITION			AG	AINST DE	PARTMENT	/PROCESS	
WOIK OIG	EI.				<u> </u>	Rework	٦		Skid-tube Cros	stube	1	Water Jet	Engineering
Part f	Vo.					Scrap	1		<u></u>	all Fab	Pro	d. Eng. Coor.	Quality
		-				Use-as-is	1		·—	ishing	Rec/Sto	re/Packaging	Other
NCR	No.					Work Order Update	]		Large Fab Com	posite		Supplier	
				,							l a: a	<del>r –</del>	
Root				1		ption of work order update		Initial	Action		Sign &		061
Cause	_	Date	Step	Qty	(	or Non-conformance	Cr	nief Eng	Description	<del></del>	Date	Verification	QC Inspector
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Equip/Tooling	Ш												
Operator	Ш		İ										
Material	$\Box$			1									
Setup	$ldsymbol{ld}}}}}}}$		<b>\</b>										
Other													
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							AUI	LT CATE	GORY				
Land	ng (	Gear			_	General	_	-		_	7	r	
	L	Bending			<u> </u>	Bend	_	Grain		⊢	Ovalized		Pressure/Forced
	<u></u>	Centre N	ot Conce	ntric to C	)/s	BOM/Route	$\perp$	Hardwa	re	<u> </u>	Over/Under	<u>+</u>	Temperature/Cure
	L	Cracks			<u> </u>	Broken/Damaged		<b>-i</b> '	on Incomplete		Part Incorre	h	Weld
<b>6</b> :	L	Crushed/	'Crimped			Burrs		4	ions Incomplete/Unclear	<u> </u>	Part Lost/M		Wrong Stock Pulled
	L	Cuffs				Contamination	_	Mainte	nance		Part Moved		
		Heat Tre	at			Countersink	L	Mislabe	led		Positioned \		
Inspection Strip in Tube Cut Too Short Misread						Power Loss/	'Surge	Other					
1		Ripples in	n Bend			Drill Holes		Offset				_	

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

<b>Work Orde</b> uly-23-13 12:5		1996		*104	1996*						Page 2
Revision ID:	D3916-041 Rib Assembly	<u>-:</u>		Accept	*N90004	4010	ነበ*	Setup	Start Stop		S1* S2*
	7/23/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:					14.	
Approvals:	Process Pla	n:	Date:		Date:		<del></del>	Run	Start Stop	*NI *NI	R1* R2*
equence ID/ Work Center II 07 *107* Large Fab .arge Fab	D	Memo	. rod Batch: M /22: hing as per dwg D3916 lds flush	Set Up/ Run Hours 3570.00	Tool ID To	ool # Pla Coo		pt Re Qt	-	Reject Number	Insp. Stamp
* <b>110</b> * <b>110*</b> QC Quality Control		QC5- Inspect part comp	leteness to step on W/O	0.00			_©	L B	<u>.OZ-</u>	Xb	0 <u>4</u> <b>0</b> 9 - <b>2</b>
120 <b>*1つ</b> ∩* QC		QC10- Inspect visual pe	er QS1004- ground welds	0.00			<u>(</u> 6	)_ B	<i>O</i> ⊱-2	)b	045 09

Quality Control

NCR: Y	'es	/ No				WORK ORDER NON-C	100	VFORM	MANCE / UPI	DATE			
											QA Closed:	Date	e: <u> </u>
Work Orde	er: _					DISPOSITION	,			AGAINST DE	PARTMENT,	<b>PROCESS</b> Water Jet	∃ e.uoo□
Part N	-				<u>_</u>	Rework Scrap Use-as-is	Skid-tube Crosstube Water Jet E  Machining Small Fab Prod. Eng. Coor.  Thermoforming Finishing Rec/Store/Packaging  Large Fab Composite Supplier						Engineering Quality Other
NCR N	١٥					Work Order Update	J		Large Fab	Composite	]	Supplier	
Root Cause		Date	Step	Qty		ption of work order update or Non-conformance		nitial ief Eng		tion ription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUL	T CATE	GORY	···			<u> </u>
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped it n Strip in ı Bend	ı Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes	-	Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/i enance eled	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Torque W	/aves in I	Extrusio	n I	Drawing		JOut of (	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

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Turning Sequence

Wave/Twist in Tube

Finish

Folio

Work Ord		4996		*104	Page 3				
Item ID: Revision ID: Item Name:	, D3916-041 Rib Assembly		· <del></del> ·	Accept	*N900040100*	Setup	Start Stop	*NS1* *NS2*	=
Start Date: Required Date Reference:	7/23/13 e: 7/23/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item 1D: Customer:				
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):	Date: Date:	Run	Start Stop	*NR1* *NR2*	
Sequence ID/ Work Center 130 *13(1* Packaging Packaging	ID	Operation Description Identify as per dwg & St	ock Location:	Set Up/ Run Hours 0.00	Tool ID Tool # Plan Acc Code Qty			Reject Insp. Number Stamp	8.26
140 *140* QC Quality Control		QC21- Final Inspection . Memo	- Work Order Release	0.00			13/	8/274	
					-		<i>[</i> .	1/1	

13-04-27

												DQA:	Da	ate:	
NCR: Y	/es	/ No				WORK ORDER NON-C	10:	VFORM	/IANCE / UP	DATE		·			
												QA Closed:	Da	ate:	
						DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS		
Work Orde	er:	<u> </u>				Rework	ıl		Skid-tube	Crosstube		1	Water Jet	-	Engineering
Part N	d a					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	-	Quality
raili	١٠٠.			<del></del>	<del></del>	Use-as-is			noforming	Finishing	_	4	re/Packaging	_	Other
NCR 1	Vo.					Work Order Update			Large Fab	Composite		,	Supplier	_	
							'								
Root					Descri	ption of work order update	Ī	Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	on_	QC Inspector
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		<u> </u>					AUI	LT CATE	GORY						
Landi	ng (					General		Grain		ı		Ovalized		$\overline{}$	Pressure/Forced
		Bending			0/5	Bend ROM/Route	$\vdash$	Hardwa			_	Over/Under	toloranco		Temperature/Cure
	<u> </u>	Centre N	ot Concei	ntric to	<sup>0/8</sup>  -	BOM/Route	$\vdash$	-1			_	Part Incorred			Weld
	$\vdash$	Cracks	C-:		<u> </u>	Broken/Damaged	$\vdash$	<b>-</b>	on Incomplete ions Incomplete/	Unclose		Part Lost/Mi		$\vdash$	Wrong Stock Pulled
	$\vdash$	Crushed/	crimped			Burrs	$\vdash$	Mainte		Oriclear		Part Lost/Wil	Billeci		I wrong stock rulled
	$\vdash$	Cuffs			$\vdash$	Countersink		Mislabe				Positioned V	Vrong		
	<b> </b>	Heat Trea		Tubo	-	Countersink Cut Too Short	-	Misread				Power Loss/	-		Other
i	1	Inspectio	กวนเหม	rube	I	Lear 100 Short	1	Livitaleac	1		l	J. 044Ct F033/	~~. Pr	Щ.	Total Control

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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July-23-13 12:58:33 PM

Work Order ID:

104996

Parent Item:

D3916-041

Parent Item Name:

Rib Assembly

Start Date: 7/23/13

Required Date: 7/23/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP RevA: New issue DD verified by:EC

IPP Rev:B as per dwg revA 10.03.15

	verified by:EC						,	<del></del>	. <u>.                                   </u>				
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measur	Qty on e Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
103759-11 Bushing		Manufactured	No			100	Each	323.0000	7	192	7	2)6	13-08-22
				Location		Loc Ot	<u>.</u>	Loc Code	•		~		
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				/100	323	2	22		_X,	18			
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					2073 189	20	)() 			<u> </u>		•	
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M304TS0.750W.049 304 SQ Tube .75x.75x.04	19W	Purchased	No	76	750	100	ſ	1,415.747	5 4.166	- <del>17:5410</del> 05:5	<del>53</del> -	20:	<u>l_13-08-22</u>
				Location		Loc Ot	<u>v</u>	Loc Code			•		
				MAT017		6.28987	54						
				12	4492	6.28987	54						•
				WA006		1409.4576	<b>1</b> 9						
				12	3484	28.99995	55						
					5124	205.4056							
				_	5575	140,2027			<u> </u>				
					26039 126364	434.849	25 00		<u> </u>	5.5			
				M	120304	0	UU						

										DQA:	· Date:	
NCR: Y	es / No				WORK ORDER NON-C	O	NFORM	MANCE / UP	DATE	QA Closed:	 Date:	
				- ·-		_						
Work Orde	er:				DISPOSITION				AGAINST DE	PAKTIVIENT	PROCESS	
	lo		· <u>-</u>		Rework Scrap		ı	Skid-tube Nachining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Sto	e/Packaging Supplier	Other
Root				Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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Equip/Tooling												
Operator [		1										
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Other		ļ				1						
Process												
Supplier	_	<u> </u>										
Training												
Unapproved		·	<u> </u>					L				<u> </u>
_	<u> </u>				···	AUL	T CATE	GORY				
Landir	ng Gear			<u> </u>	General	_	1			ام المام		Pressure/Forced
ļ	Bending	_ •		<u>.</u>	Bend	<u> </u>	Grain		-	Ovalized	<u> </u>	₹ '
}	Centre N	ot Conce	ntric to (	<sup>D/S</sup>  -	BOM/Route	-	Hardwa		<u> </u>	Over/Under	<del></del>	Temperature/Cure Weld
	Cracks			$\vdash$	Broken/Damaged		1	on incomplete	N	Part Incorre		Wrong Stock Pulled
	Crushed/	Crimped		<u> </u>	Burrs	-	4	ions Incomplete/	Unclear	Part Lost/Mi	zziuß	I wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	-	Mainte		·  -	Part Moved	Vrong	
	Heat Tre		T b	<u> </u>	Countersink	$\vdash$	Mislabe		<del> </del>	Positioned V Power Loss/	_	Other
	Inspection		9dui i	-	Cut Too Short	$\vdash$	Misread Offset	1	<u> </u>	Jrower Loss/	ourge	Tottlet
	Ripples in		F		Drill Holes	-	4	Calibration				
	Torque V	vaves in l	Extrusioi	າ	Drawing	1	LOUT OF C	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

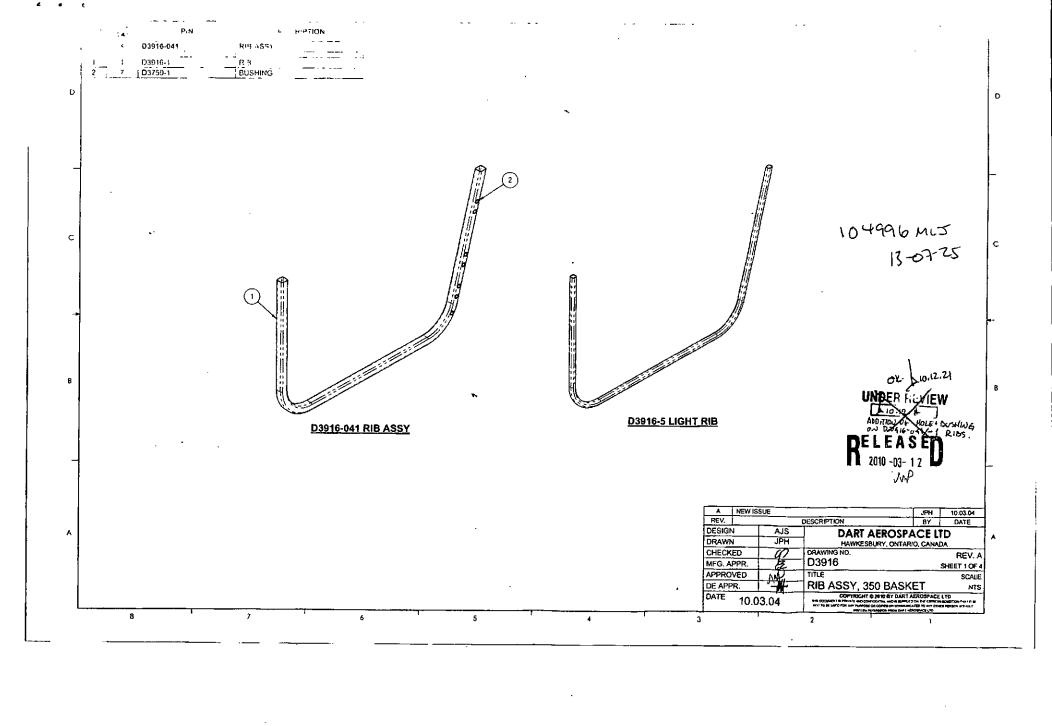
Wave/Twist in Tube

Torque Waves in Extrusion

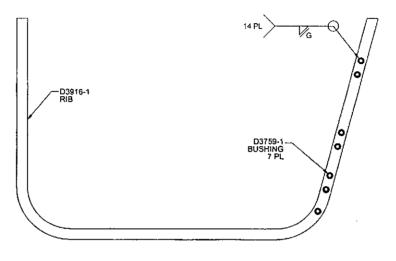
Drawing

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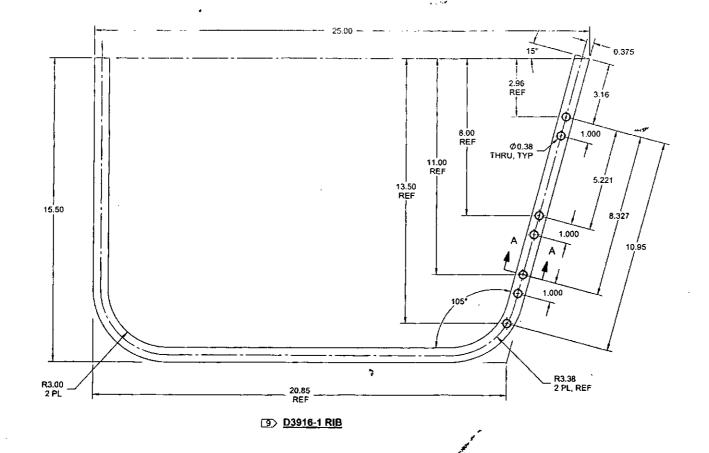
D3916-041 RIB ASSY

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT -041; 1.84 lbs
8) WELD PER DART QSI 004
•,

c

DESIGN	AJS	DART AEROSPACE	LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CAN	ADA
CHECKED	9	DRAWING NO.	REV. A
MFG. APPR.	捏	□D3916	SHEET 2 OF 4
APPROVED	AND.	TITLE	SCALE
DE APPR.		TRIB ASSY, 350 BASKET	NTS
DATE 10.0	3.04	COPYRIGHT © 2018 BY DART AEROSPAL THE DOCUMENT B HENRIS AND COMPOSITION CONTROL OF THE CAMP TO 10 JE WIETH 10th ANY PLANEAL OR COMPOSITION COMMANDLY TO TO 70'71 THE PROPERTY OF THE CAMPAIN OF THE PROPERTY OF THE CAMPAIN AND THE PROPERTY OF THE CAMPAIN AND THE PROPERTY OF THE CAMPAIN AND THE PROPERTY OF THE CAMPAIN AND THE PROPERTY OF THE CAMPAIN AND THE CAMPAIN AN	CM COMPTON PAPER IN

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BREAK EDGE 0.030 X 45\* APPROX CHAM TYP 0.049 0.75 REF REF **SECTION A-A** 

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL REF DART SPEC. M304TS0.750W.049
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: M/A

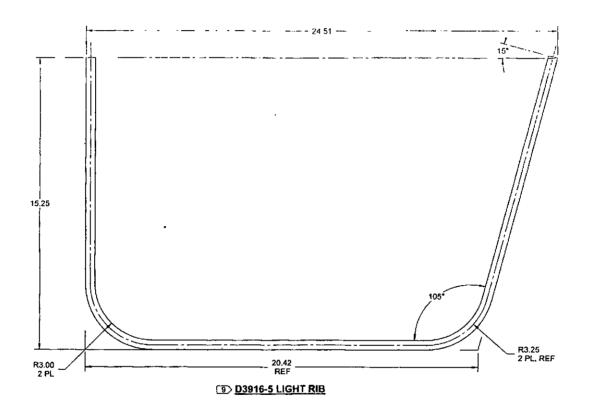
8

6) IDENTIFICATION: N/A
7) WEIGHT: 1.76 lbs
9) TUBE FLAT LENGTH 50.0 REF

DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3916 MFG. APPR. SHEET 3 OF 4 APPROVED TITLE SCALE RIB ASSY, 350 BASKET DE APPR. NTS COPYRIGHT 8 2018 6Y BART AEROSPACE LTD DATE 10.03.04

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NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL REF DART SPEC. M304TS0.500W.049
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.07 lbs
9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	0	DRAWING NO.	REV. A
MFG. APPR.	浥	↑D3916	SHEET 4 OF 4
APPROVED	W	TITLE	SCALE
DE APPR.	-	□RIB ASSY, 350 BASKET	NTS
DATE 10.03.04		COPYRIGHT IN 2016 BY CART AEROSPACE LTD THE COUNTY OF PRINTE AND CONTINUES AND IN SUPPLYS ON THE EXPERTAGE CONTINUES THAT IT IS	

